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RBE703A95-0505-00-15

Job Sheet 194585



Part No: RBE703A95-0505-00-15

Job Qty: 6 pcs

Part Name: TGB Drain Tube Quill Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/6/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A95-0505-00 Rev.L IPP Rev. A 19.02.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	6 pcs	6/14/19	6/14/19	0.00	1.20	Small Fab - 1		DAS 71 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	6 pcs	6/14/19	6/14/19	0.00	0.00	QC 5 - 10		19-5-15
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	6 pcs	6/14/19	6/14/19	0.00	0.00	Packaging 3 - 1 - B4B		DAS 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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Container No: S181666



Part: RBE703A95 - 0505 - 00 - 15

Job No: 194585

Serial No/Batch: S181666

Revision: L

Inspector:

Exp Date:

Instructions:

Date: 05/15/19

					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	6 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	QC 21 - SA - 70	QC 21 - SA - 53

Part Op 110 - 1-Cut RBE703A95-0505-00 -9 as per drawing sheet 4. 2-Cut RBE703A95-0505-00 -13 as per drawing sheet 5. 3-Descriptions: Assemble as per drawing note 7 and 8. 4-Pack as per drawing.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	1.9200 ft (.32 ea)	110-Small Fab - 1	211
2044T67	Cap Ø1.09	12 Ea (2 ea)	110-Small Fab - 1	49
9263K173	O-Ring	6 Ea (1 ea)	110-Small Fab - 1	46
PAD210	Foam Ø1 X 1 replace item 1887T48	.0840 sf (.014 ea)	110-Small Fab - 1	COORD
RBE703A95-0505-00-1	Quill	6 pcs (1 ea)	110-Small Fab - 1	133

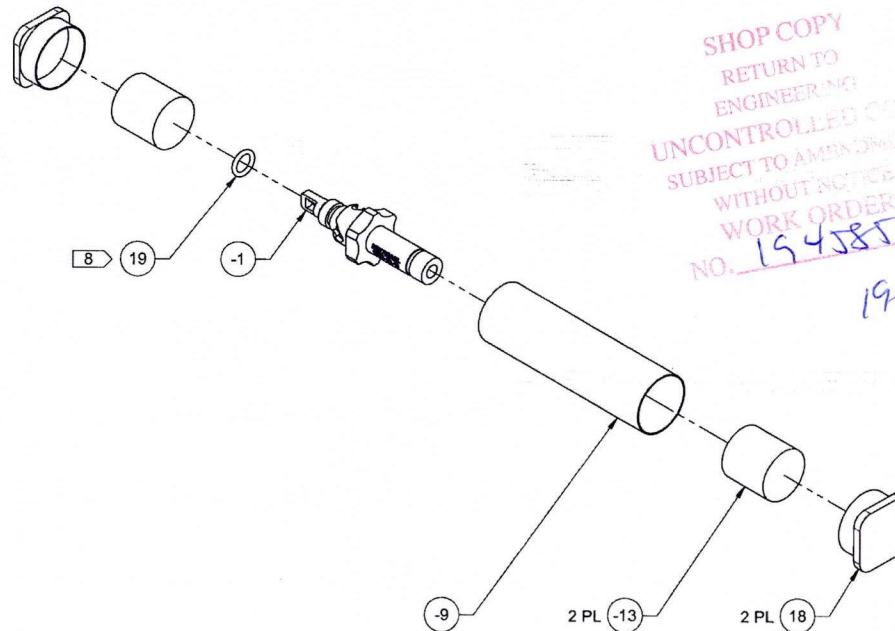
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	2044T47	2	53	0
	2044T67	12	260	0
	9263K173	6	72	0
	PAD210	0	1	0
	RBE703A95-0505-00-1	6	16	0

Part Specifications

Specifications could not be found.

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE703A95-0505-00-1	QUILL
-9	1	RBE703A95-0505-00-9	TUBE
-13	2	RBE703A95-0505-00-13	FOAM
18	2	McMaster#2044T67 OR EQUIV.	VINYL END CAP FOR 1.09" ID. SHIPPING TUBE
19	1	McMaster#9263K173 OR EQUIV.	VITON O-RING 9 mm ID. X 13 mm OD. X 2 mm WD.



RBE703A95-0505-00-15 TGB DRAIN TUBE QUILL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) IDENTIFICATION: N/A

- 7) ASSEMBLE AS SHOWN

- 8) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 19 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBE703A95-0505-00 TITLE TGB DRAIN TUBE COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. L
DRAWN	KPT		SHEET 2 OF 6
CHECKED	MBB		
MFG. APPR.	DP		
APPROVED	WJ		
DATE	2/26/2019	SCALE	NTS

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			